Work Order ID 106579 *106579* Saturday, September 07, 2013 2:52:42 PM Item ID: D3920-5 Accept *N900040100* **Revision ID:** Item Name: Seatbelt Guide Start Date: 9/6/2013 Start Qty: 4.00 **Cust Item ID: Required Date: 9/13/2013 Req'd Qty:** 4.00 **Customer:** Reference: Date: 13-47 Run Start Process Plan: / MU Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Reject Tool ID Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr -**Revision Nbr** D3920 В 100 0.00 *100* Bandsaw 0.00 Memo Jeaspa Bandsaw 1-Cut Blank at 23.800" 1 105 0.00 *105* HAAS 1 0.00 Memo HAAS CNC vertical machine #1 Machined as per folio FA810 Rev: 3 Dwg: 3920

Deburr

NCR:	Yes	/	No	

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER	NON-CO	NFORN	MANCE / UPE	DATE	QA Closed:	Date	:
Work Ord	er:					DISPOSITIO	ON			AGAINST DE		PROCESS	
Part No. Scrap Use-as-is NCR No. Work Order Update							Scrap e-as-is	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	2	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		Data	C4	01	Descr	ription of work order u	' 1	nitial	Act		Sign &	Verification	QC Inspector
Cause		Date	Step	Qty		or Non-conformance	<u>Cn</u>	ief Eng	Descr	iption	Date	vermeation	QC IIIspector
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		Cracks			<u> </u>	Broken/Damaged		'	on Incomplete		Part Incorred	-	Weld
A.		Crushed/0	Crimped		L	Burrs			ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			-	Contamination		Mainte			Part Moved		
		Heat Trea			-	Countersink	_	Mislabe			Positioned V		¬₋.
	L	Inspection		Tube	<u> </u>	Cut Too Short		Misread	l		Power Loss/	Surge	Other
	ldash	Ripples in			L	Drill Holes		Offset					
	<u> </u>	Torque W			n 'L	Drawing			Calibration				·
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		Wave/Twi	ist in Tub	e _		Folio		Outside	Dimensions				

Work Order ID 106579 *106579* Page 2 Saturday, September 07, 2013 2:52:42 PM Item ID: D3920-5 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Seatbelt Guide *4* Start Qty: 4.00 **Start Date:** 9/6/2013 **Cust Item ID:** Required Date: 9/13/2013 Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: Date: **Approvals:** Tooling: Date: Stop Date: ___ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 13/09/09 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 *120* JL13-9-10 QC 0.00 Memo Quality Control 910 ---4× 13/4/11 130 Identify as per dwg & Stock Location: 0.00

0.00

تبرك

Memo

120 Packaging

Packaging

		DQA:	Date:	
NCR: ¿Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		QA Closed:	Date:	

									QA Closed:	Date:	
Work Orde	er: 10	65	79		DISPOSITION		·	AGAINST DE	PARTMENT,	/PROCESS	
			•		Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo. L	397	0-6	5	Scrap] [Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
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Root				Descri	ption of work order update	Initial	A	ction	Sign &		
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	Crushe	d/Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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,04	inspect	ion Strip in	Tube	<u> </u>	Cut Too Short	Misre	ad		Power Loss/	Surge	Other
	_	in Bend			Drill Holes	Offset		L	•	<u> </u>	
Ⅰ 					Drawing	Out of	Calibration			-	
 					Finish	Out o	Sequence		•		
Wave/Twist in Tube Folio					Folio	\vdash	le Dimensions				

Work Order ID 106579 *106579* Saturday, September 07, 2013 2:52:42 PM Item ID: D3920-5 Accept *N900040100* Setup Start **Revision ID:** Stop Seatbelt Guide Item Name: *4* 9/6/2013 Start Qty: 4.00 **Start Date: Cust Item ID: Required Date: 9/13/2013** Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: Date:_____ Tooling: Approvals: Date: QC: Date:____ SPC (Y/N): Date: Sequence ID/ Operation -Set Up/ Tool ID Tool # Plan Reject Reject Accept **Work Center ID** Description Run Hours Qty Qty Code Number

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

MF

13.9.11

Insp.

Stamp

Page 3

				DQA:	Date:	
NCR: Yes	s / i	No	WORK ORDER NON-CONFORMANCE / UPDATE			

								-	QA Closed:	Date	e:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite	Supplier		
Root				Descri	ption of work order update	Initial	Α	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Er	ng Des	scription	Date	Verification	QC Inspector
Doc/Data											
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	Bending				Bend	Graii	1		Ovalized	L	Pressure/Forced
	Centre N	ot Conce	ntric to C	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete	L	Part Incorre	ct _	Weld
	Crushed	I/Crimped Burrs				Instr	actions Incomplete	e/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	itenance		Part Moved		
	Heat Tre	at			Countersink	Misla	beled		Positioned V	Vrong _	
	Inspection	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes	Offse	t				
	Torque Waves in Extrusion Drawing				Out of Calibration						
	Turning Sequence Finish				Out of Sequence						
	Wave/Twist in Tube				Outside Dimensions						

Picklist Print

Saturday, September 07, 2013 2:52:41 PM

Work Order ID:

106579

Parent Item:

D3920-5

Parent Item Name:

Seatbelt Guide

Start Date: 9/6/2013

Required Date: 9/13/2013

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV: A NEW ISSUE JFS 13/07/04 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.000		Purchased	No			100	f	35.5600	1.984	8.3536842	7 12 1	/L	
6061-T6 Bar .750 x 1.00				<u>Location</u>		Loc Qty	Lo	c Code	4		13/C	19/0°	3
				MAT049		35.56					٠,	,, -	(
					567	11.56							
					26351	24			8.0	oft.			

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NCR: Y	es / No)			WORK ORDER NON-C	COI	NFORM	MANCE / UP	DATE		•			
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Part N					Rework Scrap Use-as-is		Í	Skid-tube Machining noforming	Crosstube Small Fab Finishing		-1	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
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į	Heat Treat Countersink				L	Mislabe	eled			Positioned V	_	_	1	
	Inspec	ion Strip ir	n Tube		Cut Too Short		Misread	t			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

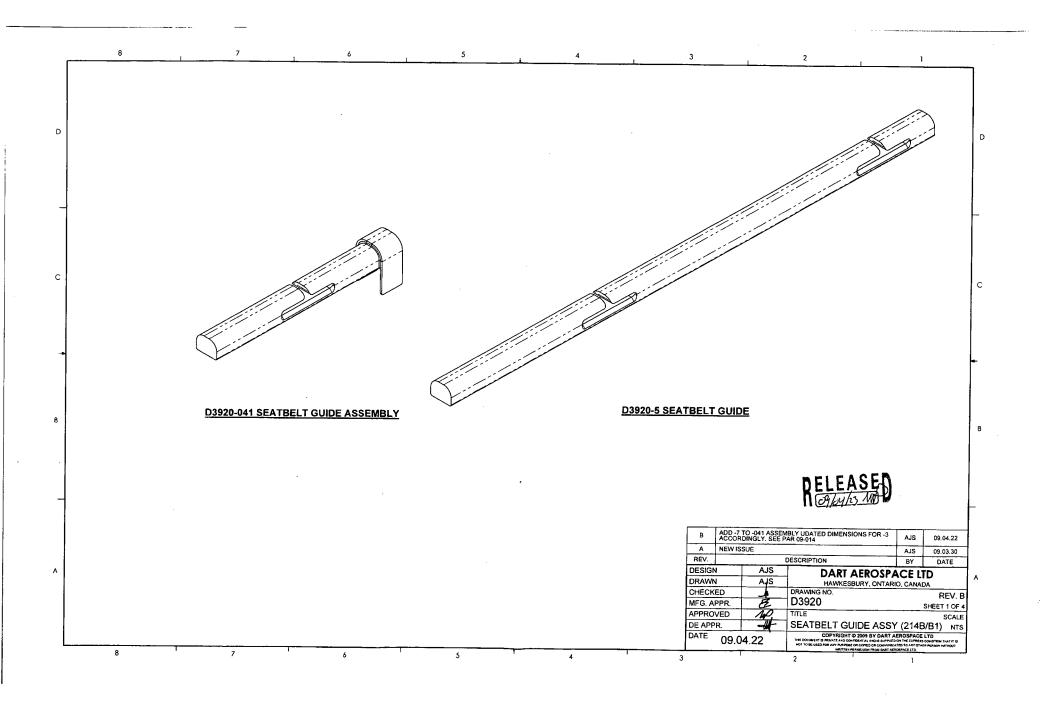
Drill Holes

Drawing

Finish

Folio

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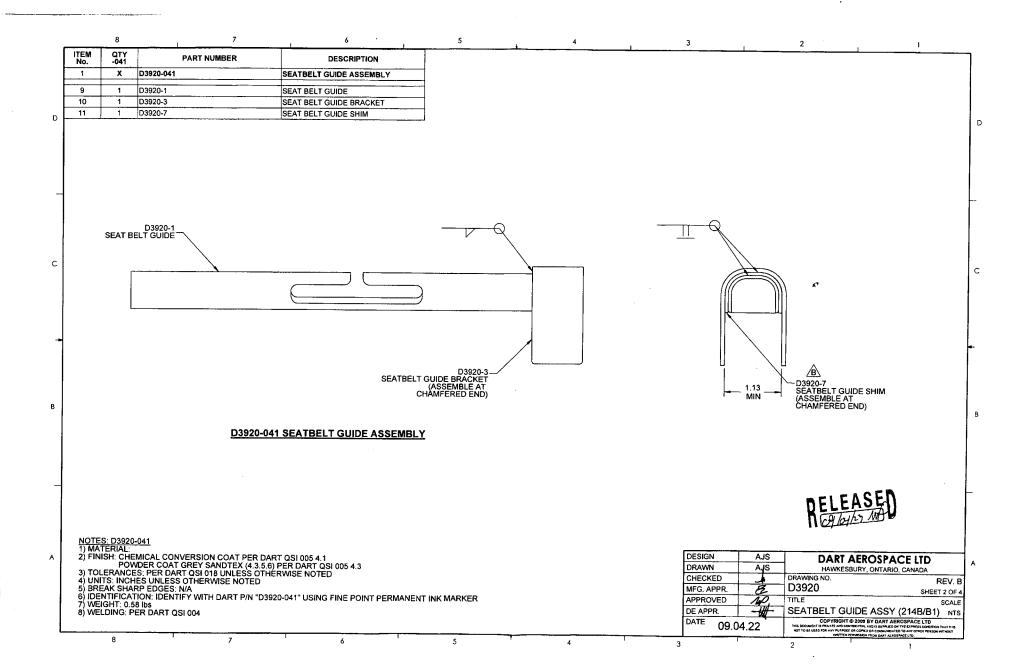


NCR:	Yes	/	No	

_Date: __

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Ĺ	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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Ī	Inspection Strip in Tube Cut Too Short Misread					•		Power Loss/	Surge	Other		
	Ripples in	n Bend			Drill Holes		Offset		-			

Out of Calibration

Out of Sequence

Outside Dimensions

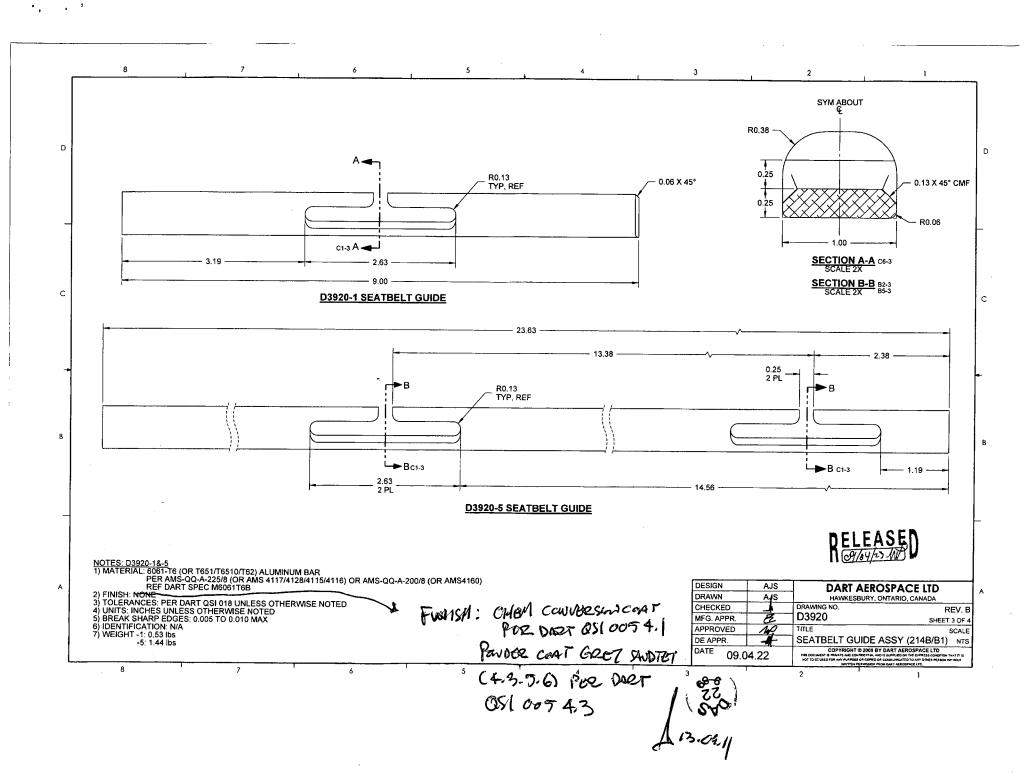
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio



										DQA:	Date.	
NCR: Y	Yes / No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE	QA Closed	 Date:	
· <u></u>					DISPOSITION				AGAINST DE			
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	Cracks		Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped Burrs						Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maintenance Part Moved						
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Offset

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

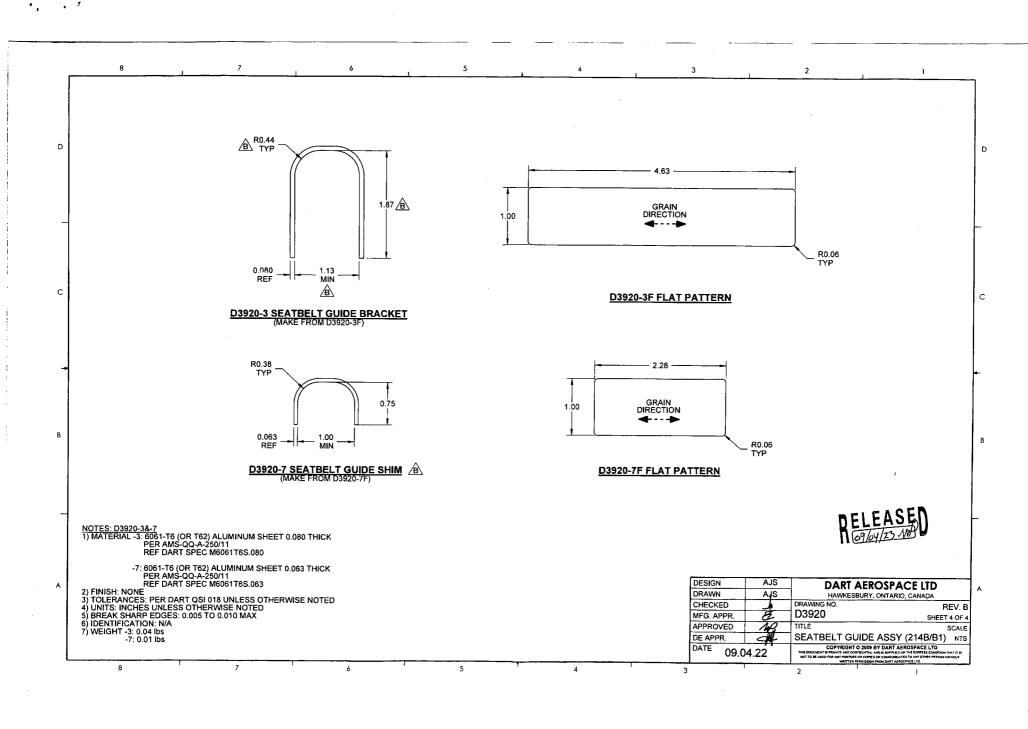
Drill Holes

Drawing

Finish

Folio

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										DQA:	Date	e:	
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Part No.			Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		<u> </u>	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other				
NCR No.			Work Order Update			Composite]						
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	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorre	ct	Weld	
	Crushed/Crimped				Burrs	Г	Instructions Incomplete/Unclear			Part Lost/M	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Maintenance			Part Moved			
	Heat Tre	at			Countersink		Mislabeled			Positioned V	Vrong		
	Inspection Strip in Tube				Cut Too Short		Misread			Power Loss/	Surge	Other	
.,	Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order: 106579	
Description: SEAT BEST GUIDE ASSY	Part Number: 03920-5	
Inspection Dwg: 03926 Rev: 13	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Actual Actual Method of							
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments	
a3.63 0	±.030	23.625	/		DP 08	TAPE MEMSURE	
2.38	t. 030	2.370	V		DR 05	6 VERN	
13.38	t.030	13.375	1		DEOS	6"NEXIO	
2.63	t.030	2.620	1		DROS	6"VERD	
1.19	I.030	1.189	/		Deos	6'VERN	
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R. 0.13	±.010	.125	<u></u>		RMOIS	GAVGIE.	
.13×45°		.175	~		Deor	6"UCRN	
.92	1,030	.247	1		DROT	6'VERN	
1.00	±.030	1.003	~		WROS	b"VERN.	
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Measured by: D. B. G	Audited by:	Preliminary Approval:
Date: /3/09/09	Date: 3-9-10	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	